

IN THE SUBSTITUTE SPECIFICATION

Please cancel paragraphs 018, 028 and 029 of the Substitute Specification, as filed with the Preliminary Amendment. Please substitute replacement paragraphs 018, 028 and 029, as follows.

[018] Undesirable vibrations of the cylinder 01, in particular undesirable bending vibrations, can occur during rotation, which bending vibrations can be caused, for example, by balance errors, by cylinder asymmetry, or by rolling off on another rotating component, which is possibly also asymmetrical. For example, one or more grooves 09, extending axially on the surface of cylinder 01 and usable for fastening non-represented dressings, or joints at the ends of dressings, constitute periodically occurring obstructions 09, which excite the undesirable bending vibrations in the cylinder 01. It is common to the obstructions 09 that they occur in an identical, or at least in similar size and order of magnitude in connection with a known stationary operating situation. A snapshot of the cylinder 01, for example at the reversing point of the vibration, is represented in dashed lines, in a greatly exaggerated manner, in Fig. 1.

[028] As represented in Fig. 5, the employment of the method of operation in accordance with the present invention is of great advantage in printing units in which two cylinder pairs, each comprised respectively of a forme cylinder 01 and of a transfer cylinder 1801, constitute a double print position for a web 2223 passing between the transfer cylinders 18, which web 2223 is to be processed, for example a web 2223 of

material to be imprinted. For example, each~~all~~ of the cylinders 01, 18 each has a circumference substantially corresponding to a length of a printed page, for example a newspaper page. The length L01 of the cylinder barrels substantially corresponds to four times the width of four side-by-side arranged printed pages, for example newspaper width. In this case, the cylinders 01 and/or 18 each have a groove 09 and/or 19~~19~~U, respectively, in the linear or axial direction. However, the dimensions of the cylinders 01, 18 can also be such that it is possible to substantially arrange two linear pages in the circumferential direction, and six, or even eight page widths of a printed page, for example a newspaper page, in the linear or axial direction. In this case, two grooves 09 and/or 19, for example, can be arranged on the circumference of the cylinders 01 and/or 18 respectively. This configuration is not specifically shown in Fig. 5.

[029] As represented in Fig. 5 a[()]], the fittings and the corresponding method of operation for one of the transfer cylinders 18 are already conceivable for effectively reducing the vibration in the area of the printing location. It is achieved that the cylinder excitations or vibrations, at least in the immediate vicinity of the web 2223 to be imprinted, are reduced. The phase of the obstructions 09, 19 is arranged in such a way that adjacent obstructions 09, 19 respectively roll off on each other.